

Work Order ID 133661

Tuesday, June 16, 2015 9:16:55 AM

133661

Page 1

Item ID: PB67-43001-197W

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Outer Tube Weldment

Stop

NS2

Start Date: 6/16/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/16/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MCS

Date: JUN 16 2015

Tooling: _____ Date: _____

Run Start

NR1

QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	D								

100

100

BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

1- Cut to length as per dwg

2- Deburr

4

Ø

J.C.L. 15/06/25

110

110

CONVENTIONAL MILLING MACHINE

0.00

Mill Conv

Memo

0.00

Conventional Milling Machine

1- Drill holes end holes using DT8792

2- Mill slot

3- Drill .125" holes

4- Deburr

4

Ø

J.C.L. 15/07/09

120

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

(4)

DAS
38
9-89

JUL 10 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Large Fab	Weld per dwg A/R Aluminum rod Batch: 130855 Large Fab	0.00				4		JUL 28 2015	DAS 24 9-89
	Memo	0.00							
	1- Weld end cap as per dwg PB67-43001 2- Grind end cap flush								
140 *140* QC Quality Control	QC10- Inspect visual per QSI004- ground welds	0.00				(4)			DAS 38 9-89 JUL 28 2015
	Memo	0.00							
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				(4)			DAS 38 9-89 JUL 28 2015
	Memo	0.00							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 133661

Tuesday, June 16, 2015 9:16:55 AM

133661

Page 3

Item ID: PB67-43001-197W

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Outer Tube Weldment

Start Date: 6/16/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/16/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
Qty
DABReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: U-27 2

0.00

160

Packaging

Memo

0.00

Packaging

④ JA 27 9-59 JUL 29 2015

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

15/1/30

SA 20150730

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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Picklist Print

Tuesday, June 16, 2015 9:16:59 AM

Page 1

Work Order ID: 133661

133661

Parent Item: PB67-43001-197W

PR67-43001-197W

Parent Item Name: Outer Tube Weldment

Start Date: 6/16/2015

Required Date: 6/16/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 15.04.02 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.750W.065		Purchased	No				f	122.5400		18			
M6061T6T1 750W 065									**				
6061T6 RDTUBE 1.750 X 0.65W													

Location	Loc Qty	Loc Code
MAT016	122.54	
M126139	72	
M126183	26.54	
M128217	24	

PB67-43001-199

Manufactured No

Each 14.0000

PR67-43001-199

Outer Tube End Cap

Location	Loc Qty	Loc Code
Mezz	14	
114054	6	
99985	8	

16.7786 J.C.L. 15/06/25

4

DAS
24
9-89

JUL 28 2015

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____																					

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

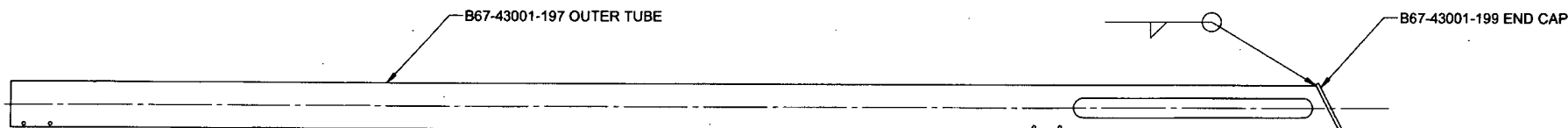
Measured by: J.C. -L.		Audited by: 38		Prototype Approval: N/A	
Date: 15/01/09		Date: JUL 10 2015		Date: N/A	

Rev	Date	Change	Revised by	Approved
A	09.05.20	New Issue	KJ	

ITEM	QTY	P/N	DESCRIPTION
	X	B67-43001-197W	OUTER TUBE WELDMENT
1	1	B67-43001-197	OUTER TUBE
2	1	B67-43001-199	END CAP

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WORK ORDER

NO. 133661 MJS
1506-16



 **B67-43001-197W OUTER TUBE WELDMENT**

RELEASED
2014-12-08
[Signature]

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.66 lbs
- 8) WELDING: PER DART QSI 004

D	ADD -197W WELDMENT (SH 1), MOVE HOLE LOCATION (ZN C7-2), REASON: TO FACILITATE MANUFACTURING	DB	14.07.22
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 16 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.02.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	H	DRAWING NO. B67-43001-197 REV. D SHEET 1 OF 2	
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>	TITLE OUTER TUBE SCALE NTS	
DE APPR.	N/A		
DATE	14.07.22	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

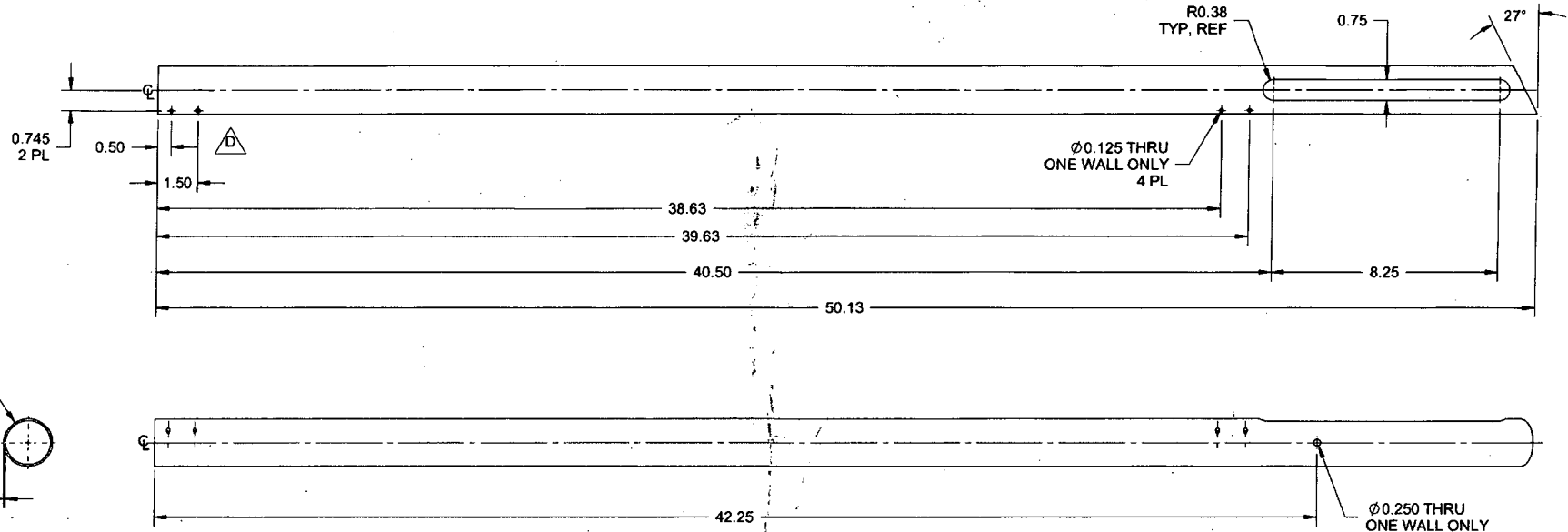
8 7 6 5 4 3 2 1

D

C

B

A



B67-43001-197 OUTER TUBE

RELEASED
2014-12-08

- NOTES:**
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING
PER WW-T-700/6 OR AMS4080 OR AMS 4082 OR
AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF. DART SPEC. M6061T6T1.750W.065
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.62 lbs

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA.	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		B67-43001-197	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	OUTER TUBE	NTS
DATE	14.07.22	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1